

Date: Thursday, 5/3/2007 11:38:59 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SADDLE
Job Number : 32203
Estimate Number : 12451
P.O. Number : N/A Part Number : D35001
This Issue : 5/3/2007 S.O. No. : N/A Drawing Number : D3500 REV C
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : C
Previous Run : 31934 Material : N/A Due Date : 6/10/2007 Qty: 30 Um: Each
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 06-06-15 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6102013 6061-T6 7.0x6.5x2.0



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)
6061-T6 7.0x6.5x2.0
350 Saddle Billet
Batch: 1533681

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. SA Double check by: J.L

1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets
4-Deburr
5-Tumble to remove sharp edges.

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 07.08.08

SA 07.11.08

J.F 07/11/09 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:38:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 32203

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JS

07-11-12

(X30)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M105914

MS
MS

07/11/12

(30X) (9X) (10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

JS JS

07-11-14

(X21)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51440

JS

AS 07/11/14

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(21)

2011/15

Job Completion



U 07.11.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/11/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-11-13	6.0	9 prints have defects / in the print. Can 2.C: Contaminates from the dirty rinse tank.	AS1012	- drain rinse tank, and re-fill with clean water. - Scuff affected areas with a scotch brite. - Touch-up areas with Alclad 1000 - Re-powder coat while per AS1005	M. 07/11/12 M. 07/11/12	07-11-13 07-11-13	AS1012 07-11-13	

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32203
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.483	0.490		.484	.484	.486	.485		
B	1.175	1.185		1.180	1.179	1.180	1.182		
C	3.145	3.155		3.148	3.148	3.150	3.151		
D	1.175	1.185		1.180	1.179	1.180	1.180		
E	0.365	0.385		.377	.378	.379	.378		
F	0.490	0.510		.500	.492	.498	.495		
H	R.470	R.530		.525	R.525	R.525	R.525		
I	R1.575	R1.595		R.1578	1.581	1.579	1.575		
J	0.240	0.260		.253	.254	.253	.252		
K	0.490	0.510		.501	.501	.501	.501		
L	3.590	3.650		3.625	3.623	3.625	3.625		
M	0.315	0.320		.316	.316	.320	.320		
N	0.256	0.262		.257	.257	.258	.257		
O	6.500	6.520		6.510	6.511	6.507	6.505		
P	5.990	6.010		6.008	6.008	6.006	6.005		
Q	2.820	2.830		2.825	2.823	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.124	1.125		
U	0.540	0.560		.553	.554	0.549	0.549		
V	0.793	0.803		.797	.797	.797	.796		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		.050	.050	0.50	0.50		
Y	0.100	0.120		.120	.120	.120	.120		
AA	R1.125	R1.145		R.1129	1.130	1.130	1.126		
AB	R.490	R.510		R.500	.500	R.500	R.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.260	.260	.260	.260		
AE	1.810	1.830		1.821	1.821	1.818	1.818		
AF	0.240	0.260		.251	.251	.252	.252		
AG	0.140	0.160		.150	.152	.152	.152		
AH	0.140	0.160		.155	.153	.153	.153		
AI	0.140	0.160		.155	.149	.153	.151		
Accept/Reject									

Measured by:	SA
Date:	07.11.05

Audited by:	J.F.
Date:	07/11/09

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	32203
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486	.486	.486	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.151	3.150	3.152	3.152		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.377	.378	.377	.377		
F	0.490	0.510		.503	.496	.495	.497		
H	R.470	R.530		R.525	R.525	R.51	R.5		
I	R1.575	R1.595		1.585	1.586	1.583	1.581		
J	0.240	0.260		.253	.253	.252	.253		
K	0.490	0.510		.501	.502	.495	.501		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.257	.258	.258	.258		
O	6.500	6.520		6.508	6.508	6.508	6.508		
P	5.990	6.010		6.004	6.006	6.006	6.007		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.252		
T	1.120	1.130		1.125	1.129	1.127	1.128		
U	0.540	0.560		.551	.550	.551	.548		
V	0.793	0.803		.799	.794	.795	.797		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.120	.120	.120	.120		
AA	R1.125	R1.145		R1.132	R1.132	R1.130	R1.132		
AB	R.490	R.510		R.500	R.500	R.500	R.500		
AC	0.615	0.635		.635	.635	.632	.634		
AD	0.240	0.260		.260	.260	.260	.259		
AE	1.810	1.830		1.819	1.819	1.817	1.816		
AF	0.240	0.260		.253	.252	.251	.250		
AG	0.140	0.160		.152	.152	.151	.150		
AH	0.140	0.160		.153	.154	.154	.152		
AI	0.140	0.160							
Accept/Reject									

Measured by:	SC/DA
Date:	07.11.07

Audited by:	J.F.
Date:	07/11/07

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	32203
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1 5	2 6	3 7	4 8	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.181	1.180		
C	3.145	3.155		3.148	3.148	3.149	3.149		
D	1.175	1.185		1.180	1.180	1.181	1.179		
E	0.365	0.385		.379	.379	.379	.379		
F	0.490	0.510		.502	.502	.500	.497		
H	R.470	R.530		R.525	R.525	R.525	R.525		
I	R1.575	R1.595		1.580	1.581	1.575	1.579		
J	0.240	0.260		.253	.253	.258	.253		
K	0.490	0.510		.499	.500	.500	.501		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.319	.319	.319	.319		
N	0.256	0.262		.258	.258	.257	.258		
O	6.500	6.520		6.508	6.507	6.508	6.507		
P	5.990	6.010		5.994	5.994	5.998	5.998		
Q	2.820	2.830		2.825	2.825	2.825	2.827		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.252		
T	1.120	1.130		1.124	1.125	1.125	1.130		
U	0.540	0.560		.556	.547	.546	.544		
V	0.793	0.803		.797	.796	.797	.797		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		0.120	.120	.120	.120		
AA	R1.125	R1.145		R1.128	R1.129	R1.126	R1.134		
AB	R.490	R.510		R.500	R.500	R.500	R.500		
AC	0.615	0.635		.625	.625	.625	.620		
AD	0.240	0.260		.260	.260	.260	.254		
AE	1.810	1.830		1.815	1.815	1.815	1.817		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.152	.153	.152	.147		
AI	0.140	0.160		.147	.145	.153	.148		
Accept/Reject									

Measured by:	EC / MIA
Date:	07.11.07

Audited by:	J.F.
Date:	07/11/09

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	32203
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1 9	2 10	3 11	4 12	By	Date
A	0.483	0.490		.485	.486	.486	.485		
B	1.175	1.185		1.180	1.179	1.180	1.179		
C	3.145	3.155		3.149	3.150	3.150	3.149		
D	1.175	1.185		1.179	1.180	1.180	1.178		
E	0.365	0.385		.377	.379	.379	.378		
F	0.490	0.510		.497	.501	.500	.495		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.578	1.579	1.578	1.580		
J	0.240	0.260		.252	.251	.253	.251		
K	0.490	0.510		.500	.503	.503	.499		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.319	.320	.320	.319		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.507	6.506	6.505	6.507		
P	5.990	6.010		5.997	5.999	6.001	6.001		
Q	2.820	2.830		2.824	2.826	2.826	2.824		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.249	2.249	2.2500	2.253		
T	1.120	1.130		1.125	1.128	1.126	1.127		
U	0.540	0.560		.544	.545	.549	.546		
V	0.793	0.803		.797	.800	.802	.801		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.120	.120	.120	.120		
AA	R1.125	R1.145		1.132	1.133	1.132	1.133		
AB	R.490	R.510		R.500	R.500	R.500	R.500		
AC	0.615	0.635		.630	.628	.630	.629		
AD	0.240	0.260		.253	.253	.254	.254		
AE	1.810	1.830		1.817	1.817	1.817	1.817		
AF	0.240	0.260		.250	.250	.249	.250		
AG	0.140	0.160		.151	.150	.150	.150		
AH	0.140	0.160		.146	.147	.146	.146		
AI	0.140	0.160		.148	.148	.147	.148		
Accept/Reject									

Measured by:	36 / 94
Date:	07.11.07

Audited by:	J.F.
Date:	07/11/09

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	32203
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486	.485	.485	.786		
B	1.175	1.185		1.181	1.178	1.179	1.179		
C	3.145	3.155		3.157	3.148	3.145	3.155		
D	1.175	1.185		1.181	1.178	1.175	1.175		
E	0.365	0.385		.378	.377	.378	.379		
F	0.490	0.510		.497	.498	.499	.499		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.583	1.5835	1.587	1.586		
J	0.240	0.260		.252	.254	.250	.250		
K	0.490	0.510		.502	.500	.495	.493		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.257	.257	.258		
O	6.500	6.520		6.509	6.508	6.507	6.510		
P	5.990	6.010		6.008	6.008	6.005	6.004		
Q	2.820	2.830		2.825	2.825	2.825	2.823		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.251	2.251	2.255	2.250		
T	1.120	1.130		1.128	1.128	1.127	1.124		
U	0.540	0.560		.553	.551	.551	.549		
V	0.793	0.803		.799	.799	.799	.799		
W	R.240	R.260		R.250	.250	.250	R.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.120	.120	.120	.120		
AA	R1.125	R1.145		1.132	1.133	1.136	1.136		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.254	.254	.255	.254		
AE	1.810	1.830		1.818	1.818	1.815	1.815		
AF	0.240	0.260		.247	.247	.250	.252		
AG	0.140	0.160		.149	.149	.152	.152		
AH	0.140	0.160		.151	.150	.150	.149		
AI	0.140	0.160		.146	.150	.150	.149		
Accept/Reject									

Measured by:	SA
Date:	07.11.08

Audited by:	J.F.
Date:	07/11/09

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	32203
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		1.175	1.175	1.175	1.175		
B	1.175	1.185		1.175	1.175	1.175	1.181		
C	3.145	3.155		3.145	3.145	3.145	3.145		
D	1.175	1.185		1.175	1.175	1.175	1.181		
E	0.365	0.385		0.378	0.378	0.378	0.377		
F	0.490	0.510		0.497	0.502	0.501	0.497		
H	R.470	R.530		0.525	0.525	0.523	0.525		
I	R1.575	R1.595		1.584	1.586	1.586	1.581		
J	0.240	0.260		0.249	0.248	0.248	0.249		
K	0.490	0.510		0.502	0.502	0.502	0.501		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		0.320	0.320	0.320	0.320		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.510	6.509	6.509	6.510		
P	5.990	6.010		6.003	5.999	5.999	6.007		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.123	1.126	1.127	1.126		
U	0.540	0.560		0.551	0.549	0.545	0.550		
V	0.793	0.803		0.800	0.799	0.799	0.801		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.120	0.120	0.120	0.120		
AA	R1.125	R1.145		1.134	1.135	1.136	1.135		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.254	0.254	0.254	0.255		
AE	1.810	1.830		1.814	1.814	1.814	1.814		
AF	0.240	0.260		0.251	0.250	0.250	0.250		
AG	0.140	0.160		0.151	0.151	0.150	0.152		
AH	0.140	0.160		0.148	0.148	0.149	0.148		
AI	0.140	0.160		0.150	0.151	0.150	0.150		
Accept/Reject									

Measured by:	SA
Date:	02.11.08

Audited by:	J.F.
Date:	02/11/09

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	32203
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486	.486				
B	1.175	1.185		1.175	1.181				
C	3.145	3.155		3.175	3.157				
D	1.175	1.185		1.175	1.180				
E	0.365	0.385		.377	.370				
F	0.490	0.510		.501	.501				
H	R.470	R.530		.525	.525				
I	R1.575	R1.595		1.557	1.580				
J	0.240	0.260		.251	.251				
K	0.490	0.510		.495	.501				
L	3.590	3.650		3.625	3.625				
M	0.315	0.320		.320	.320				
N	0.256	0.262		.258	.258				
O	6.500	6.520		6.570	6.570				
P	5.990	6.010		5.998	6.001				
Q	2.820	2.830		2.825	2.825				
R	2.495	2.505		2.500	2.500				
S	2.245	2.255		2.250	2.250				
T	1.120	1.130		1.125	1.125				
U	0.540	0.560		.545	.545				
V	0.793	0.803		.799	.800				
W	R.240	R.260		.250	.250				
X	0.040	0.060		.050	.050				
Y	0.100	0.120		.120	.120				
AA	R1.125	R1.145		1.136	1.155				
AB	R.490	R.510		.500	.500				
AC	0.615	0.635		.630	.630				
AD	0.240	0.260		.255	.255				
AE	1.810	1.830		1.815	1.815				
AF	0.240	0.260		.250	.250				
AG	0.140	0.160		.151	.151				
AH	0.140	0.160		.145	.150				
AI	0.140	0.160		.151	.149				
Accept/Reject									

Measured by: SD	Audited by: JF
Date: 07.11.08	Date: 07/11/09

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	



